

Date: Wednesday, 12/7/2005 8:29:09 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CONSOLE BRACKET (206))
Job Number : 25143	
Estimate Number : 11007	
P.O. Number : N/A	Part Number : D2607
This Issue : 12/7/2005 S.O. No. : N/A	Drawing Number : D2607 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : 12/7/2005 Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : N/A	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 1/10/2006 Qty: 10 Um: Each
Checked & Approved By : <u>SEE COMMENT BELOW</u>	
Comment : Est. E 02.06.05 Added alodine finish TSR 1290 NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.1313 sf(s)/Unit Total : 1.3125 sf(s)
 2024-T3 .040 sheet
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 Stack of 10
 (M2024T3S.040) Batch M17052

En 05/12/16 20

2.0	SHEAR	SHEAR
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Comment: SHEAR 1900
9.000 x 2.000 (10030)
 Cut Blank per template DT6247

En 05/12/16 20

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine per folio D2607

En 05/12/16

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 05/12/16

5.0	QC8	SECOND CHECK
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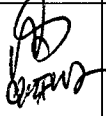
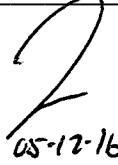
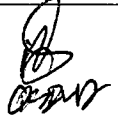
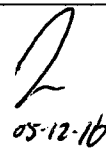


Comment: SECOND CHECK

J.L 05.12.16 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/11/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/12/16	3.0	one stack (10 parts) scrap moved in clamps		Scrap and Destroy and Replate.	EP 05/12/16	 05-12-16		 05-12-16

NOTE: Date & initial all entries

Date: Wednesday, 12/7/2005 8:29:09 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE BRACKET (2061)

Job Number: 25143

Part Number: D2607

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2607

SPB 06/01/16 20
SAD 118/12/05 / 20

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-01-16 20

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FF 06-01-19

20

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 48

ml 06/01/27

06/127 20

20

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

5.5 06/01/30

20

06/01/30

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	25143
Description: Console Bracket		Part Number:	D2607
Inspection Dwg: D2607 Rev: A1		Page 1 of 1	

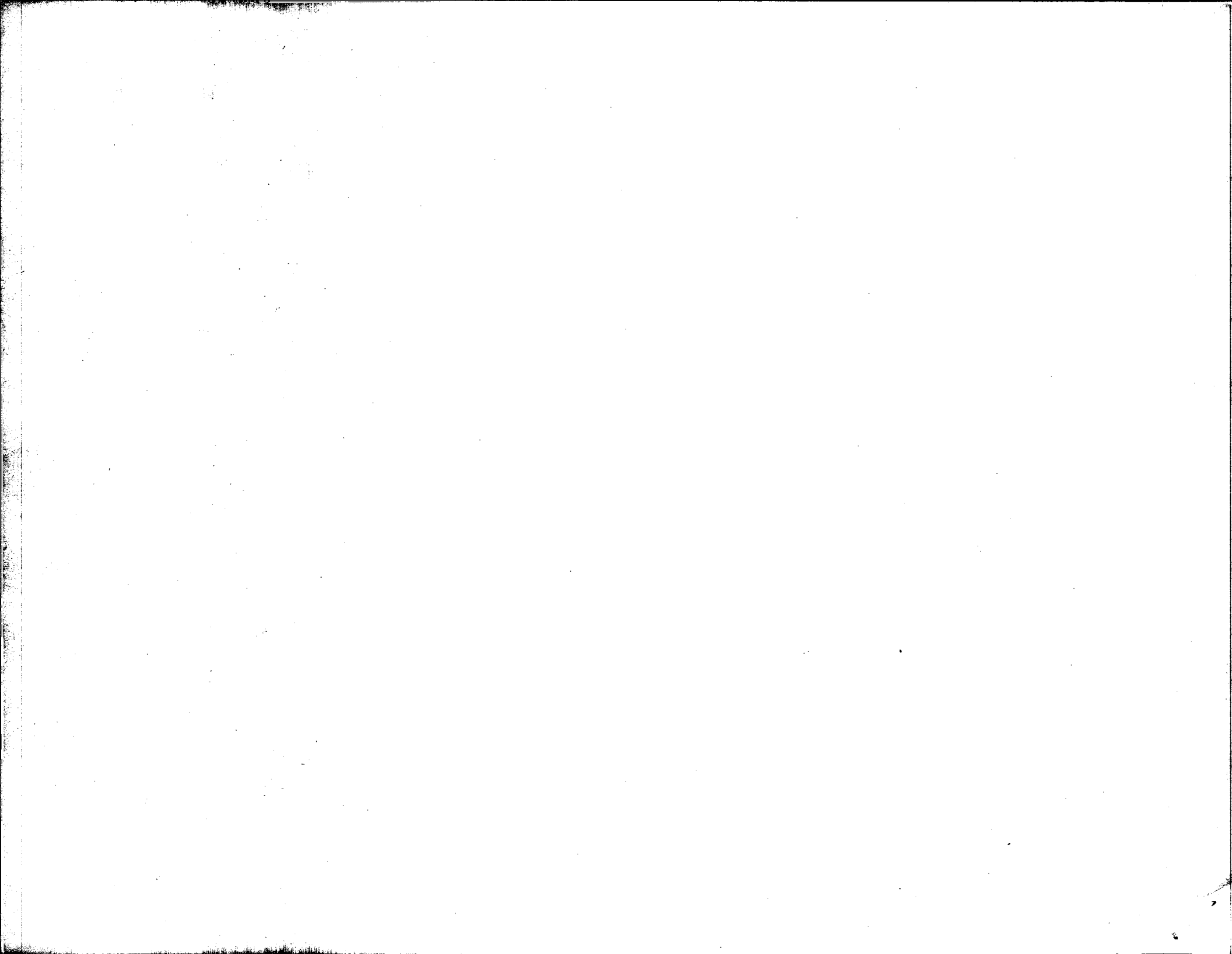
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.674	+/-0.010	1.677	✓			
R0.250	+/-0.010	0.250	✓			
0.220	+/-0.005	0.220	✓			
R0.156	+/-0.010	0.156	✓		R/L	
8.710	+/-0.010	8.715	✓			
1.891	+/-0.010	1.901	✓			Sharp Edge
1.454	+/-0.005	1.453	✓			
0.200	+/-0.005	0.202	✓			
8.930	+/-0.010	8.935	✓			
Ø0.098	+0.005/-0.000	0.098	✓			
0.040	+/-0.005	0.039	✓			mat. H. screws

Measured by: Ep	Audited by: S.G	Prototype Approval:	N/A
Date: 05/21/16	Date: 05/12/16	Date:	N/A

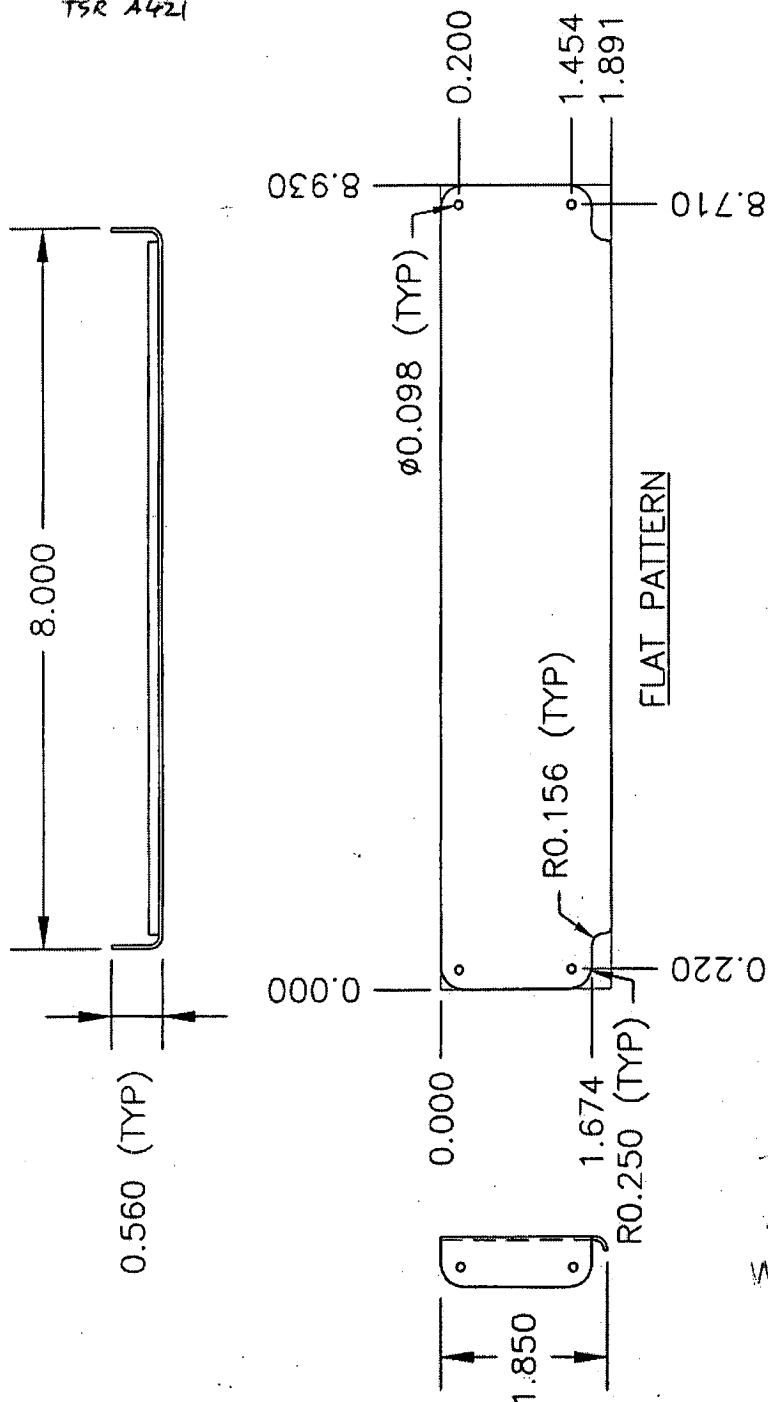
Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	





DESIGN <i>KE</i>	DRAWN BY <i>BW</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2607	REV. A SHEET 1 OF 1
DATE 97.10.23		TITLE CONSOLE BRACKET	SCALE 1:2
A	97.10.23	D2607 WAS D206-547-9	
AI	<i>AI</i> 02.06.04	ADD FINISH	

RELEASED
97.11.04 KE
TSR A421



WORK ORDER
NO. 25143

MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2607
BEND RADIUS 0.093
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1